ABSTRACT

A machining system (SYS) for carrying out manufacturing in assembly lines is provided with individual tool units (WE1, WE2, ..., WEn) that each include a holding device (3-1, 3-2, ..., 3-n). The individual tool units (WE1, WE2, ..., WEn) also comprise a position determination device (PBE1, PBE2, ..., PBn) that determines the position of the tool unit along a retaiing rail (4), in which the tool units are suspended. A control unit (ST1, ST2, ..., STn) adjusts machining parameter sets according to the position of the tool units detected in the aforementioned manner. The retaining rail (4) is preferably provided in the form of a retaining rail, in which a conductor rail (11) and a data rail (10) are integrated whereby rendering trailing of the cable unnessary for conducting data communications and for supplying power. This configuration of tool units enables an easy and user-friendly execution of a simple reverse clocking and a simple expansion of the machining system with additional machining sections (BA1, BA2, ..., Ban) and additional tool units (WE1, WE2, ..., WEn).